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(54) **INJECTION MOLDING APPARATUS**

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See application file for complete search history.

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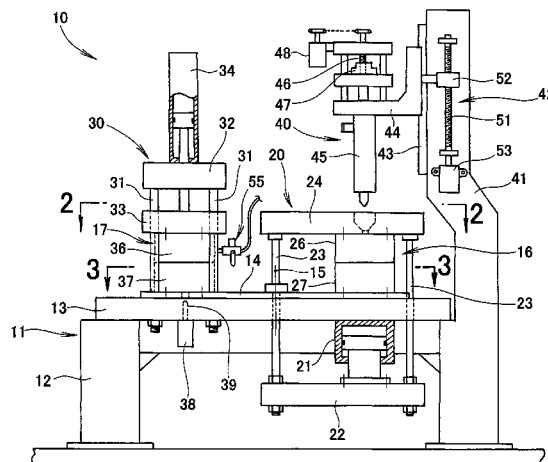
CPC .. B29C 45/04; B29C 45/0441; B29C 45/045;

(57)

ABSTRACT

An injection molding apparatus has at least two mold clamping mechanisms for clamping respective molds. A hydraulic pressure supply source supplies hydraulic pressure to the at least two mold clamping mechanisms to clamp the respective molds. A hydraulic-pressure-supply-destination selection section is configured to allow hydraulic pressure from the hydraulic pressure supply source to be selectively supplied to any one of the two mold clamping mechanisms. At least two injecting machines are configured to inject resin material to the respective molds clamped by the respective two mold clamping mechanisms. A non-hydraulic power supply source drives the at least two injecting machines to inject the resin material.

20 Claims, 9 Drawing Sheets



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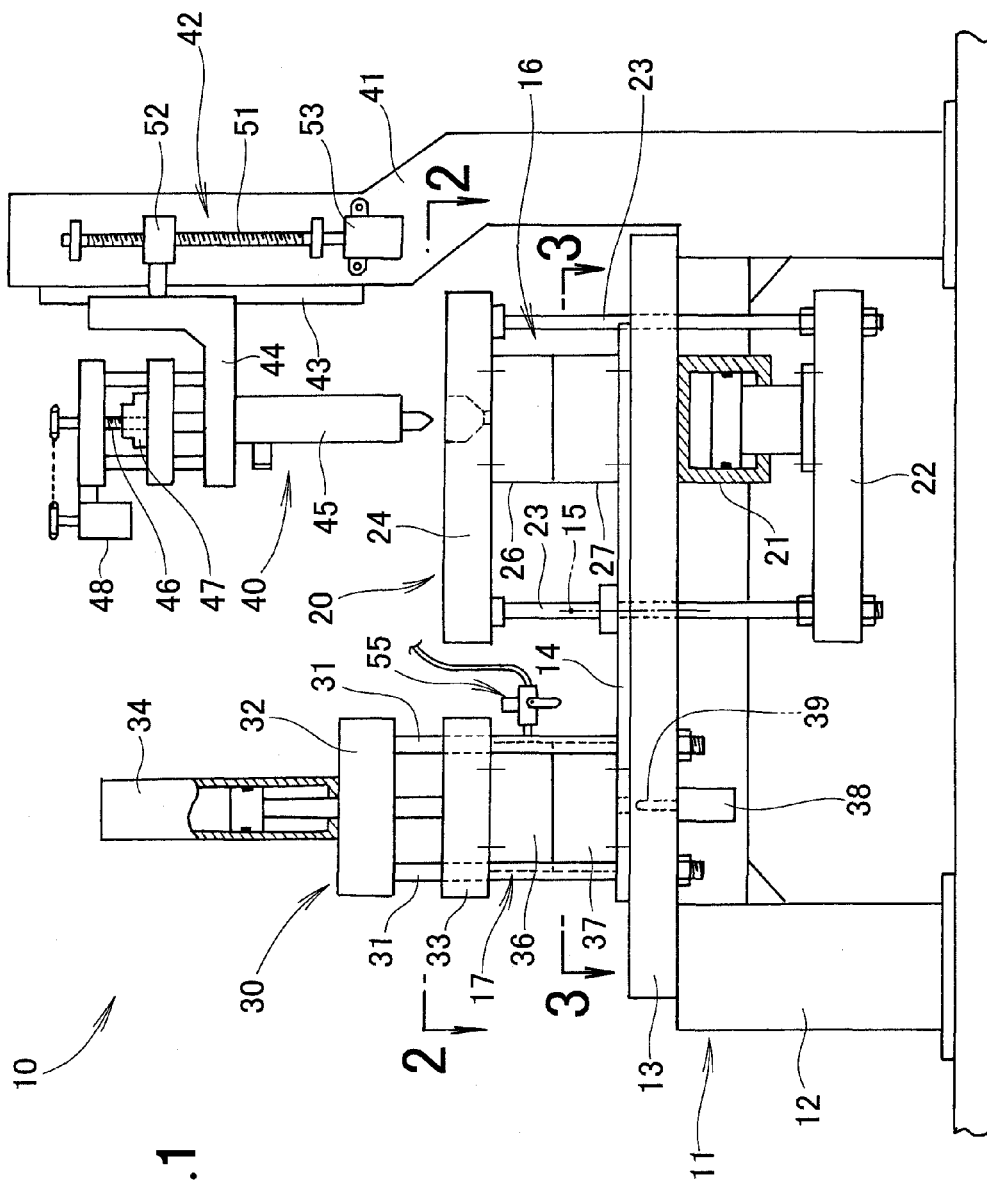


FIG. 1

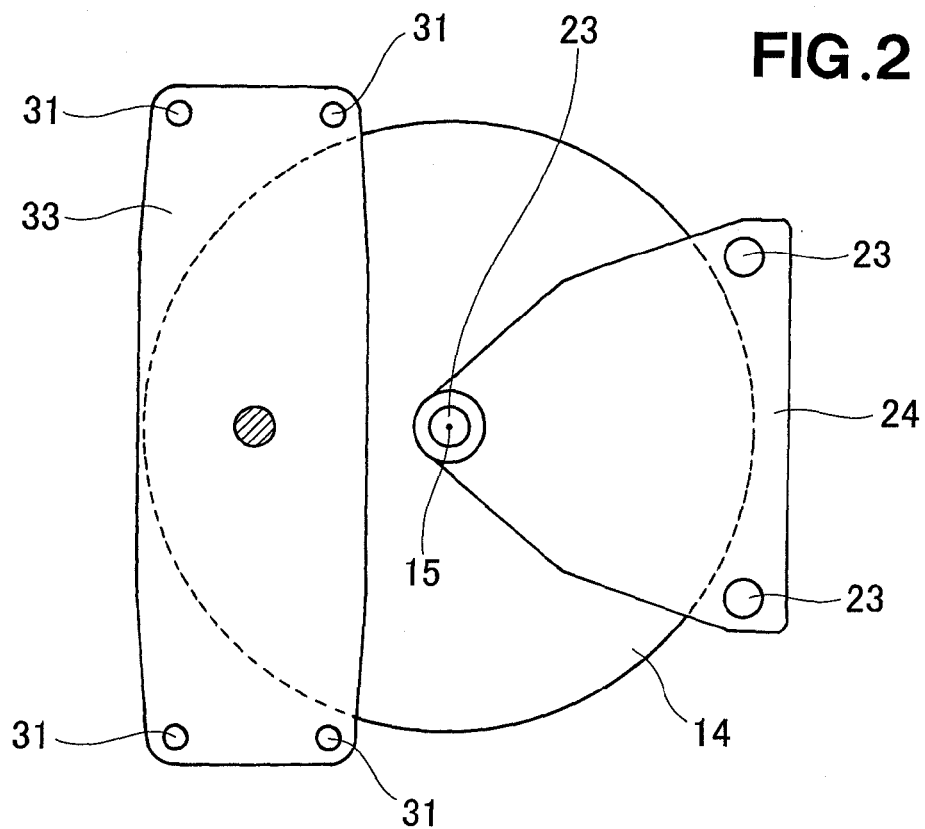


FIG. 3

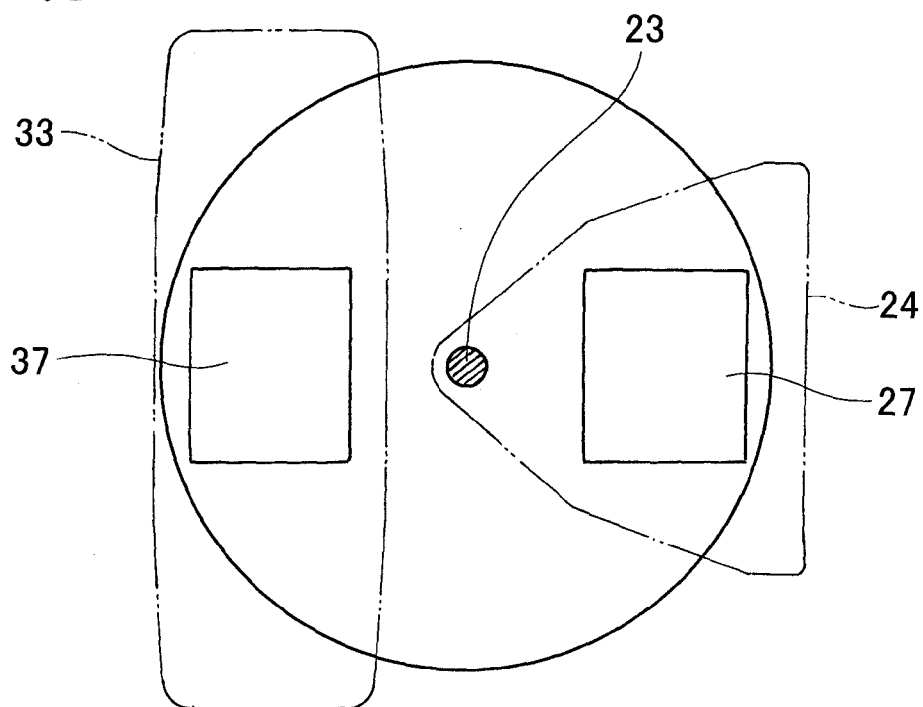


FIG. 4

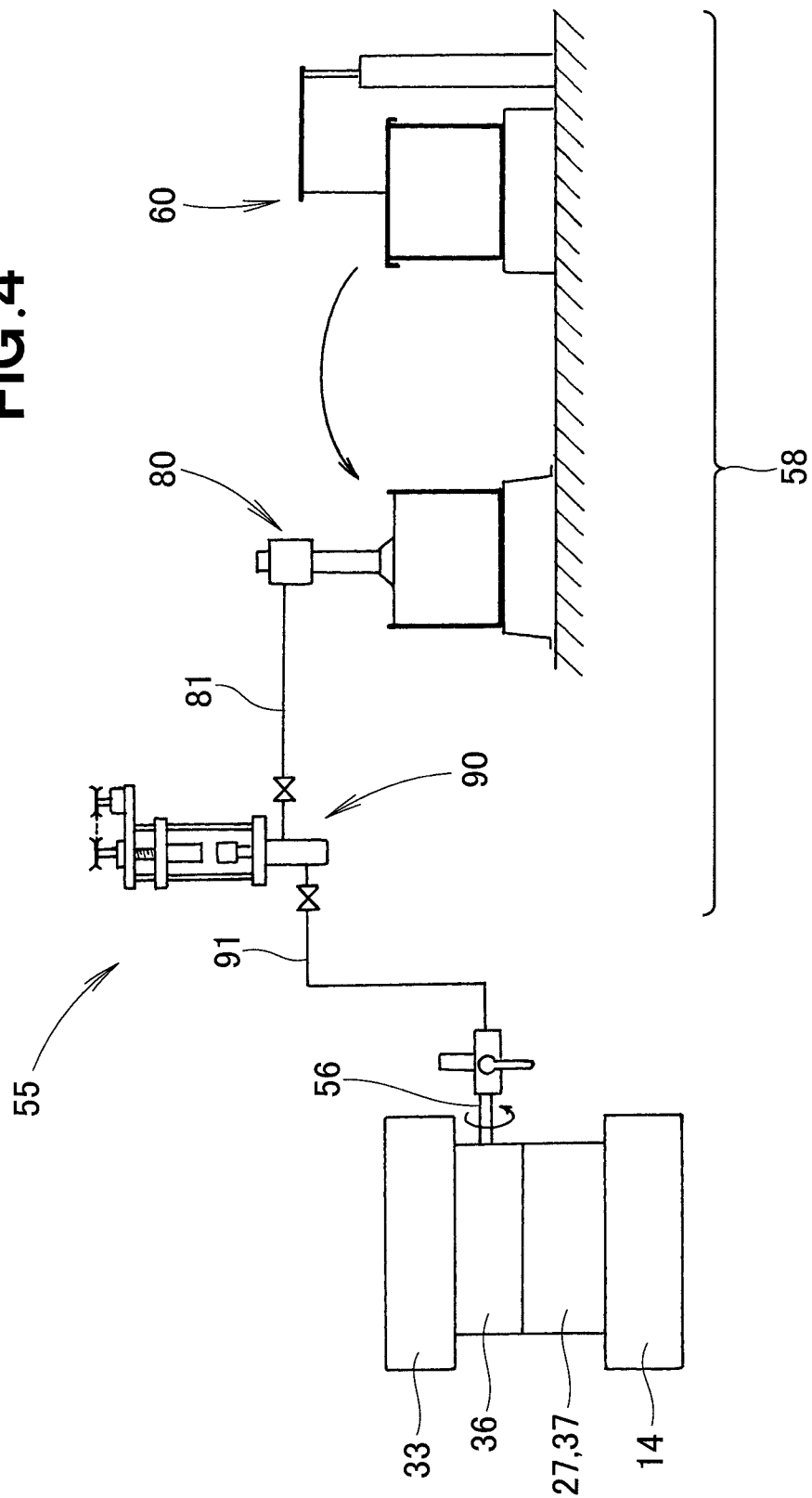


FIG. 5

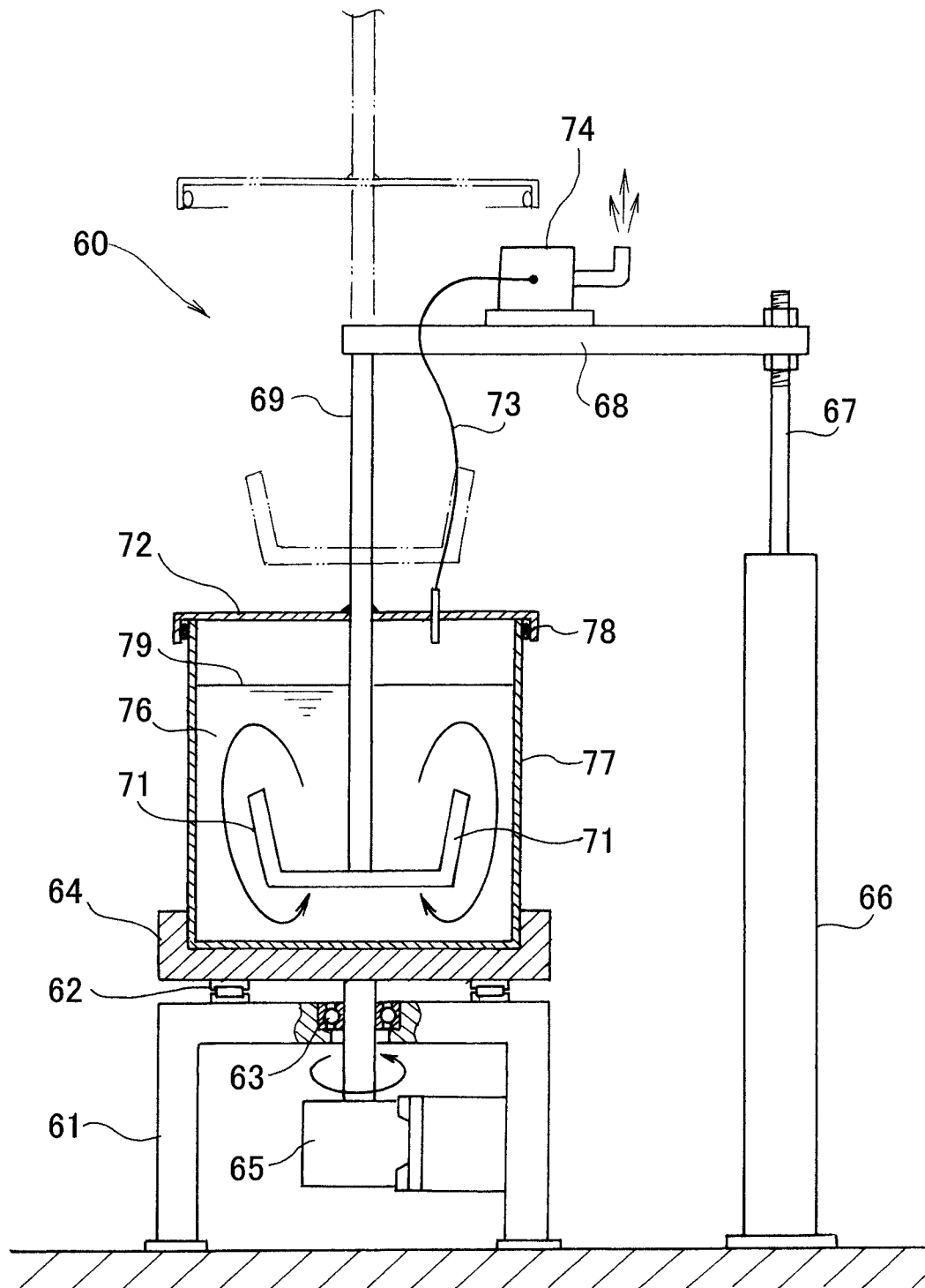


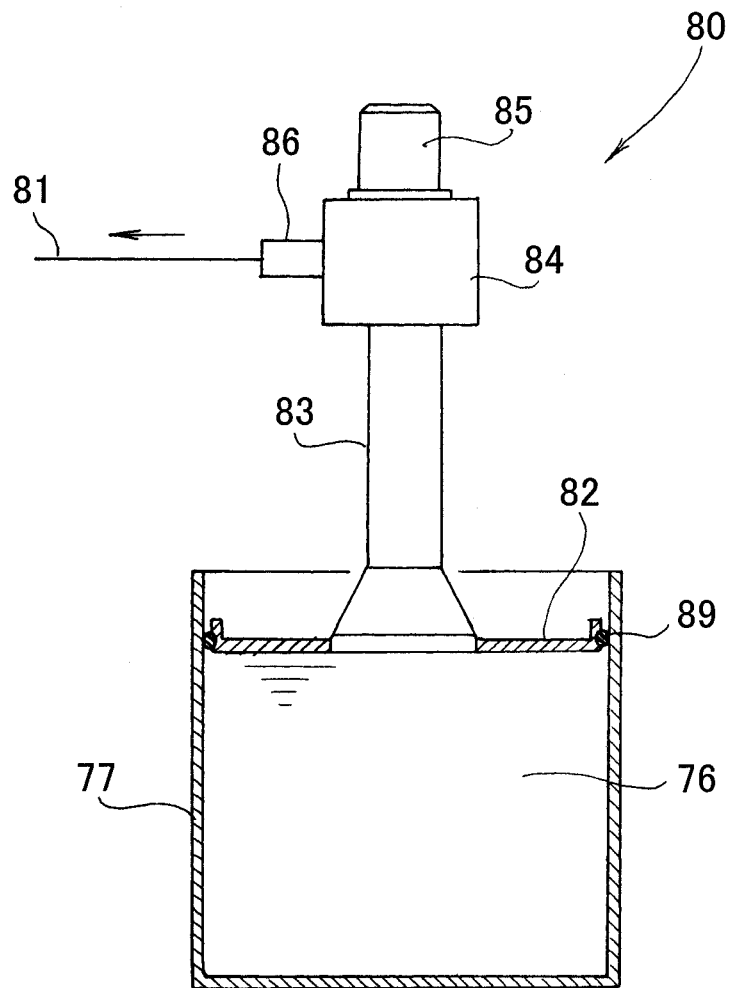
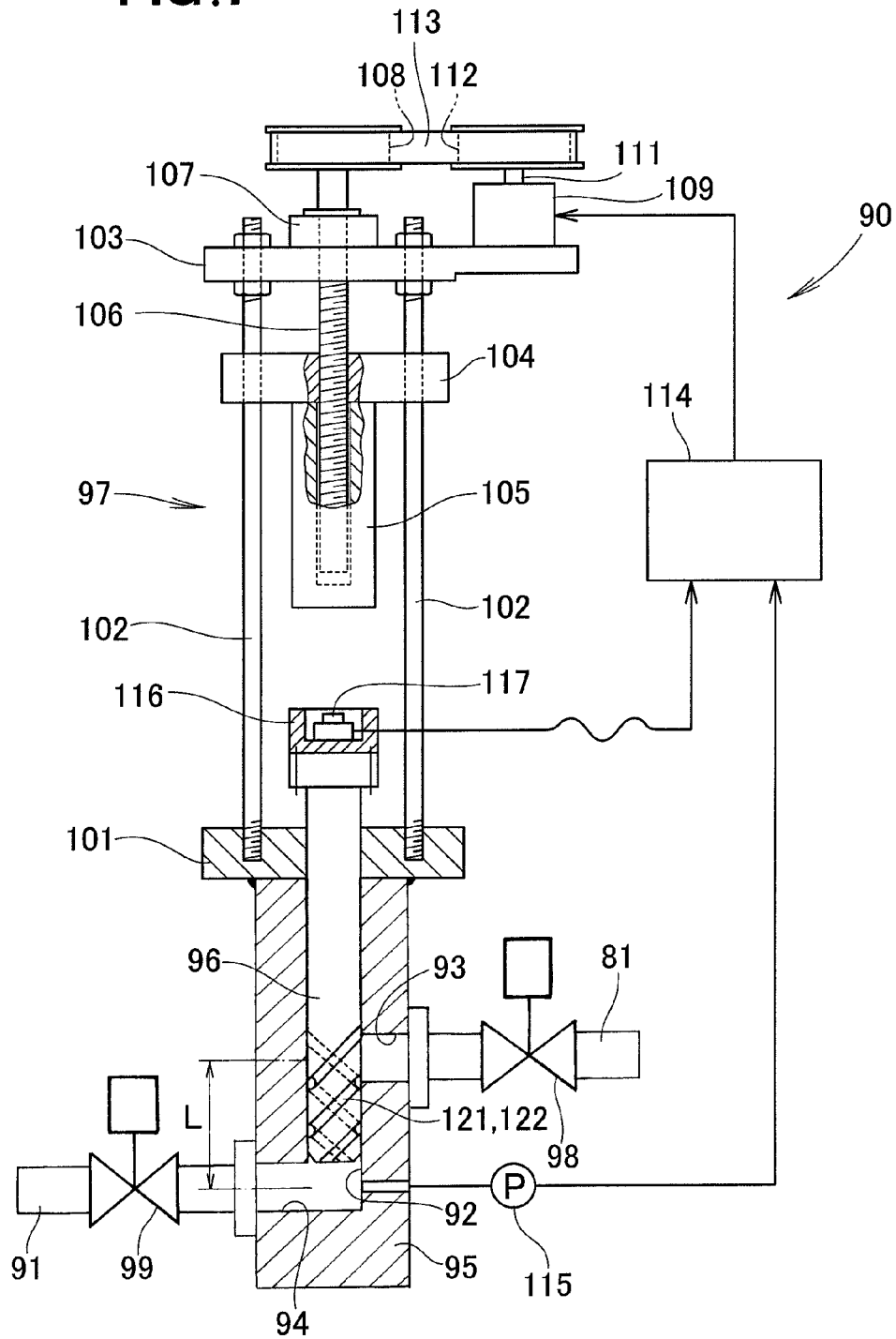
FIG. 6

FIG.7



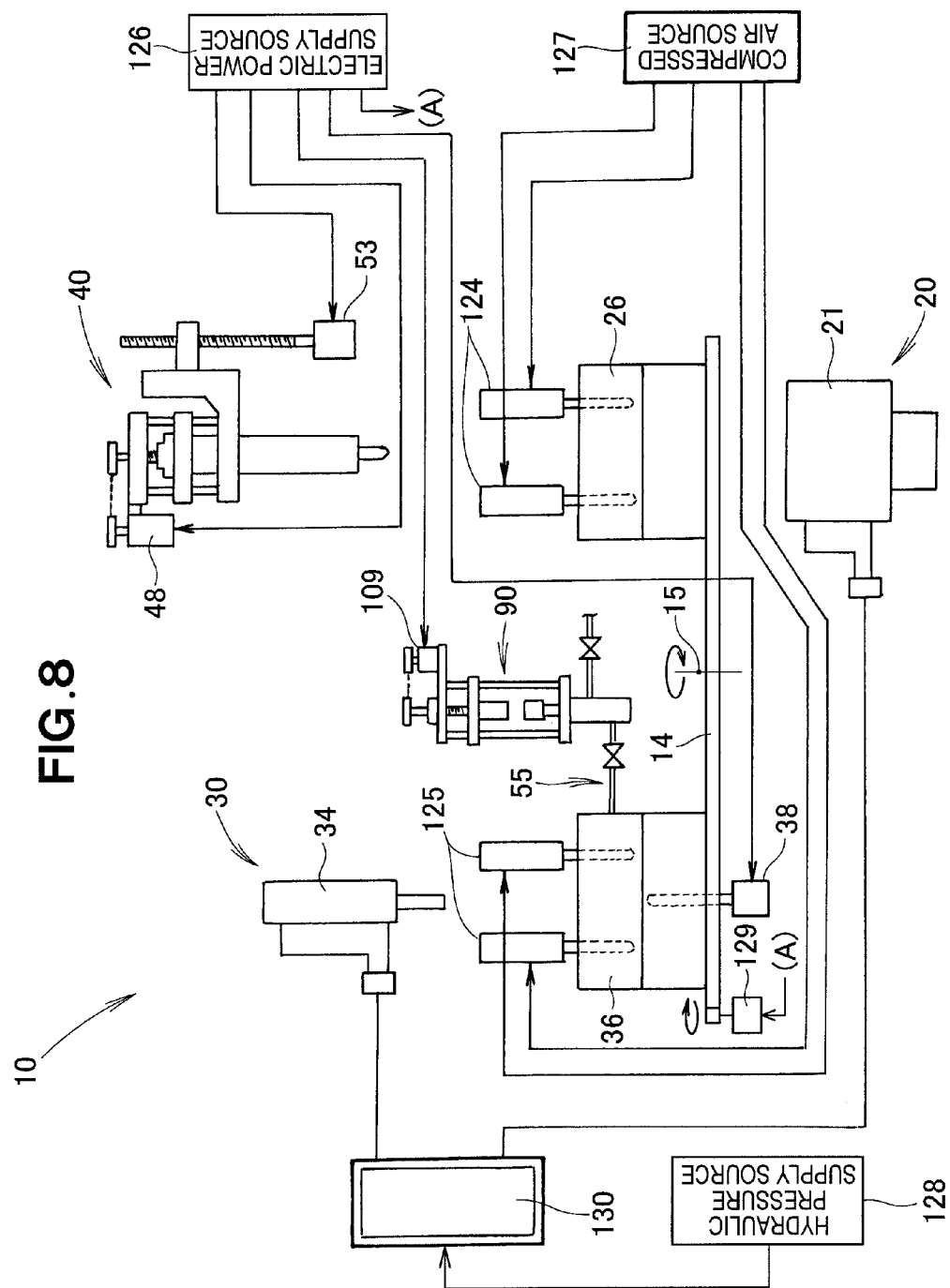
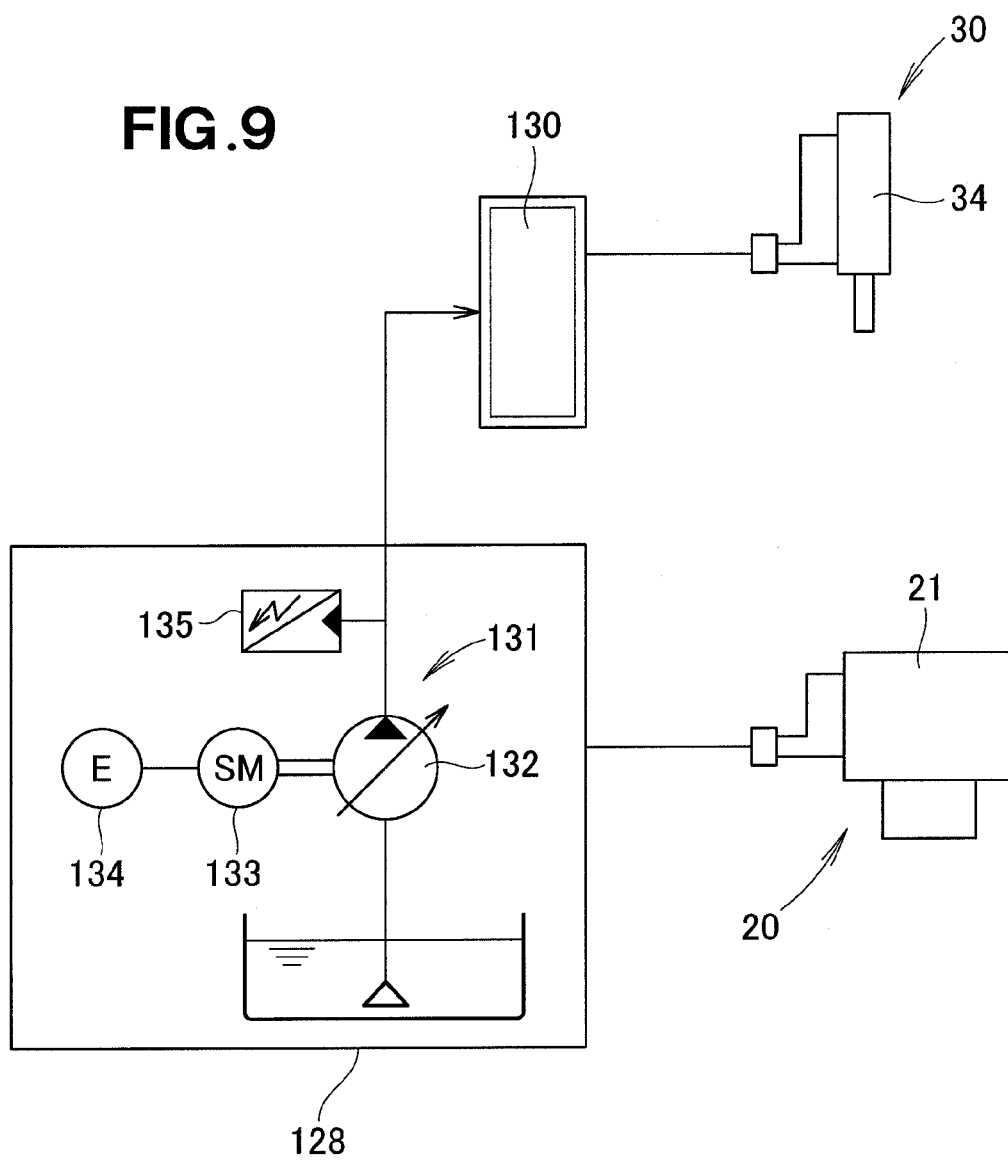
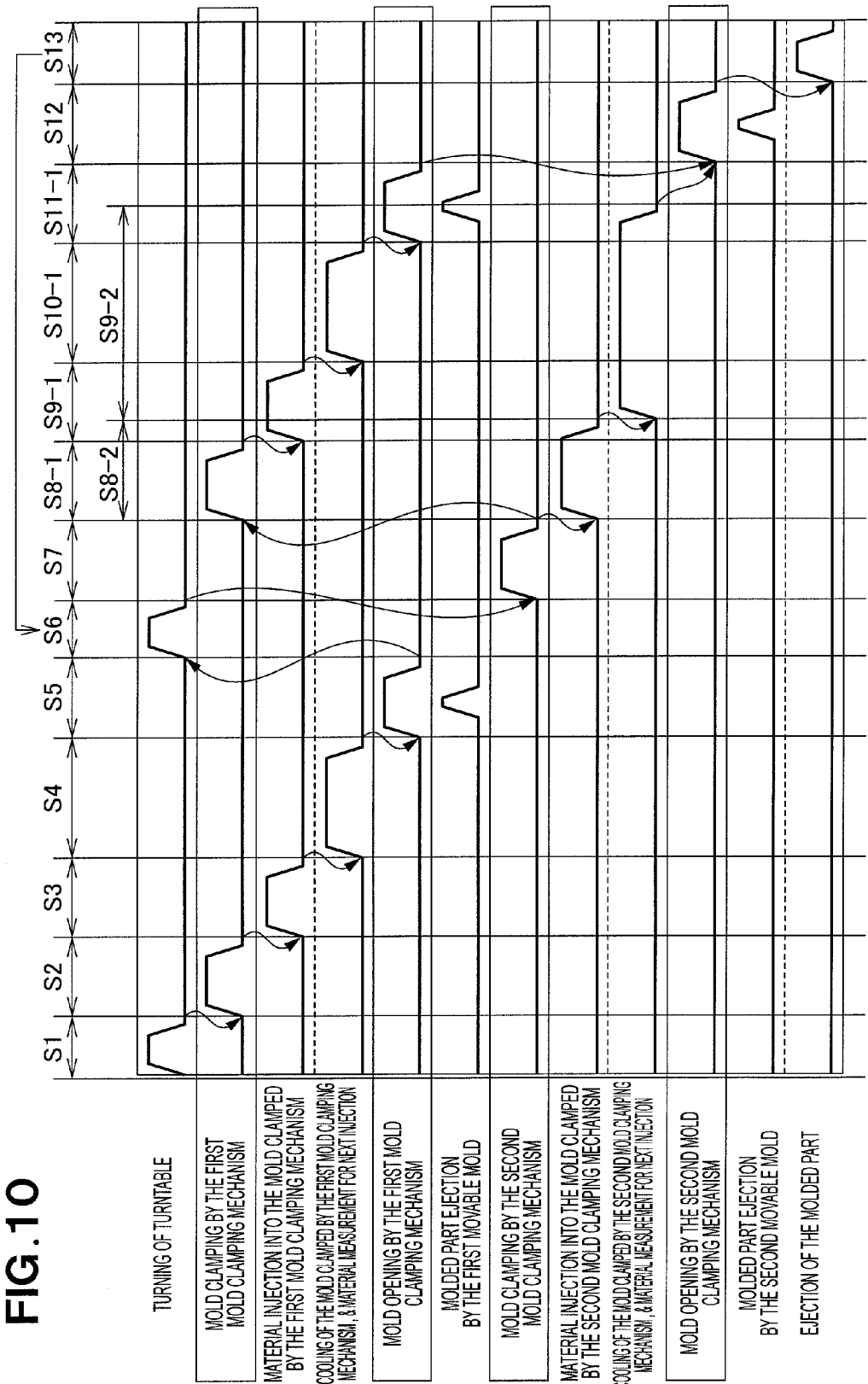


FIG.9





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INJECTION MOLDING APPARATUS**FIELD OF THE INVENTION**

The present invention relates to an injection molding apparatus provided with a plurality of mold clamping mechanisms.

BACKGROUND OF THE INVENTION

Many of the injection molding apparatus known today include one mold clamping mechanism and one injection molding machine, and they are constructed in such a manner that resin material is injected into an injection mold, clamped by the mold clamping mechanism, to obtain a molded part or workpiece. However, the known injection molding apparatus have limitations in terms of productivity. Thus, there have been proposed injection molding apparatus that include a plurality of mold clamping mechanisms and a plurality of injecting machines, one example of which is disclosed in Japanese Patent Application Laid-open Publication No. 2003-320545 that will hereinafter be referred to as "the relevant patent literature" (see particularly FIGS. 1 and 2 of the relevant patent literature).

The injection molding apparatus disclosed in the relevant patent literature includes, as shown in FIGS. 1 and 2 of the relevant patent literature, two injecting machines, two mold clamping mechanisms, one oil tank and one hydraulic pump. One of the injecting machines is driven by a hydraulic cylinder provided as an injecting cylinder, one of the mold clamping mechanisms is driven by a hydraulic cylinder provided as a mold clamping cylinder, the other of the injecting machines is driven by a hydraulic cylinder provided as another injecting cylinder, and the other of the mold clamping mechanisms is driven by a hydraulic cylinder provided as another mold clamping cylinder. Hydraulic pressure is supplied from the hydraulic pump to all of the above-mentioned four hydraulic cylinders.

Because the four hydraulic cylinders are sometimes driven simultaneously, the hydraulic pump has a capacity capable of simultaneously driving the four hydraulic cylinders. Therefore, the hydraulic pump would unavoidably become large in size and costly, but also an amount of electric power to be supplied to an electric motor for driving the hydraulic pump would increase and thus electricity cost would increase.

In actual operation of such an injection molding apparatus, all of the hydraulic cylinders are sometimes driven simultaneously, and only one or some of the hydraulic cylinders are sometimes driven. However, even in the case where only one or some of the hydraulic cylinders are driven, considerable electricity cost would be required for driving the large hydraulic pump. Therefore, there has been a demand for an improved technique capable of downsizing the hydraulic pump in order to achieve energy saving or conservation and cost reduction of the injection molding apparatus.

SUMMARY OF THE INVENTION

In view of the foregoing prior art problems, it is an object of the present invention to provide an improved technique which, in an injection molding apparatus provided with a plurality of hydraulic-type mold clamping mechanisms, can downsize a hydraulic pressure supply source that drives the mold clamping mechanisms.

In order to accomplish the above-mentioned object, the present invention provides an improved injection molding apparatus, which comprises: a plurality of mold clamping

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mechanisms; a single hydraulic pressure supply source provided for supplying mold clamping hydraulic pressure to the plurality of mold clamping mechanisms; a hydraulic-pressure-supply-destination selection section for making a hydraulic-pressure supply destination selection such that hydraulic pressure is supplied from the hydraulic pressure supply source to any one of the plurality of mold clamping mechanisms; a turntable for shifting injection molds, disposed thereon, between the mold clamping mechanisms; a plurality of injecting machines provided in association with respective ones of the plurality of mold clamping mechanisms for injecting resin material to the injection molds clamped by the corresponding mold clamping mechanisms; and an electric power supply source or a compressed air supply source provided for supplying driving electric power or compressed air to the plurality of injecting machines.

In the injection molding apparatus of the present invention, including the plurality of mold clamping mechanisms and the plurality of injecting machines, the mold clamping mechanisms are driven by hydraulic pressure while the injecting machines are driven by electric power or compressed air. In the case where only the mold clamping mechanisms are driven by hydraulic pressure like this, the necessary capacity of the hydraulic pressure supply source can be lowered as compared to a case where all of the mold clamping mechanisms and the injecting machines are driven by hydraulic pressure.

Further, in the injection molding apparatus of the present invention, the hydraulic-pressure-supply-destination selection section allows hydraulic pressure to be supplied to a selected one of the mold clamping mechanisms. In the case where only a selected one of the mold clamping mechanisms is driven at a time like this, the necessary capacity of the hydraulic pressure supply source can be halved as compared to a case where the plurality of mold clamping mechanisms are driven simultaneously. Thus, the present invention can significantly lower or reduce the necessary capacity of the hydraulic pressure supply source and thus can reduce the size of, or downsize, the hydraulic pressure supply source but also significantly reduce electricity cost required for driving the hydraulic pressure supply source.

Preferably, the injection molding apparatus of the present invention further comprises an ejection mechanism for ejecting a molded product from the injection mold, and the driving electric power or compressed air is supplied from the electric power supply source or the compressed air supply source to the ejection mechanism. Because driving by hydraulic pressure is not employed for the ejection mechanism, it is not necessary to increase the capacity of the hydraulic pressure supply source, so that further size reduction or downloading of the hydraulic pressure supply source can be achieved.

Preferably, in the injection molding apparatus of the present invention, the hydraulic pressure supply source is a hydraulic pump, a discharge flow rate of the hydraulic pump being variable by the number of rotations of a drive motor that drives the hydraulic pump being variably controlled. If a servo motor is used as the drive motor, the present invention can achieve enhanced energy conservation performance, reduced running cost and enhanced responsiveness of the hydraulic pump, but also enhanced accuracy and precision of control of the injection molding apparatus.

Preferably, in the injection molding apparatus of the present invention, the resin material to be injected by one of the injecting machines is thermoplastic resin, while the resin material to be injected by another of the injecting machines is non-thermoplastic resin different from the thermoplastic resin. By the provision of the hydraulic-pressure-supply-des-

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mination selection section, mold clamping by the one mold clamping mechanism and mold clamping by the other mold clamping mechanism can be performed with a proper time difference therebetween or at proper non-overlapping timing, and mold opening by the one mold clamping mechanism and mold opening by the other mold clamping mechanism can be performed with a proper time difference therebetween or at proper non-overlapping timing. Thus, even different kinds of material that differ from each other in length of time necessary for being cooled within the respective molds can be used for injection molding by the injection molding apparatus of the invention, and thus, double-color molding etc. can be performed with ease by the injection molding apparatus of the invention.

Further, preferably, in the injection molding apparatus of the present invention, the non-thermoplastic resin is liquid mixed material obtained by stirring and mixing liquid resin material and a curing agent. Although the thermoplastic resin and the liquid resin material completely differ from each other in the necessary cooling time, such different kinds of material used for injection molding by the injection molding apparatus of the invention.

The following will describe embodiments of the present invention, but it should be appreciated that the present invention is not limited to the described embodiments and various modifications of the invention are possible without departing from the basic principles. The scope of the present invention is therefore to be determined solely by the appended claims.

BRIEF DESCRIPTION OF THE DRAWINGS

Certain preferred embodiments of the present invention will hereinafter be described in detail, by way of example only, with reference to the accompanying drawings, in which:

FIG. 1 is a front view of an embodiment of an injection molding apparatus of the present invention;

FIG. 2 is a view taken along arrowed line 2-2 of FIG. 1;

FIG. 3 is a view taken along arrowed line 3-3 of FIG. 1;

FIG. 4 is a view illustrating principles of a second injecting machine in the injection molding apparatus of the present invention;

FIG. 5 is a view illustrating principles of a stirring and mixing mechanism in the injection molding apparatus of the present invention;

FIG. 6 is a view illustrating principles of a pump mechanism in the injection molding apparatus of the present invention;

FIG. 7 is a view illustrating principles of a measure and supply mechanism in the injection molding apparatus of the present invention;

FIG. 8 is a view illustrating principles of a plurality of types of drive sources for driving the injection molding apparatus of the present invention;

FIG. 9 is a detailed view of a hydraulic drive source in the injection molding apparatus of the present invention; and

FIG. 10 is a time chart illustrating behavior of the injection molding apparatus of the present invention.

DETAILED DESCRIPTION OF THE INVENTION

As shown in FIG. 1, an embodiment of an injection molding apparatus 10 of the present invention includes: a machine stand 11 having a leg 12 and an upper board 13; a turntable 14 pivotably provided on the upper board 13; first and second injection molds 16 and 17 disposed symmetrically with respect to a pivot shaft 15 of the turntable 14; first and second mold clamping mechanisms 20 and 30 for clamping the

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molds 16 and 17, respectively; a first injecting machine 40 provided in association with the first mold clamping mechanism 20 for injecting resin material to the mold 16; and a second injecting machine 55 provided in association with the second mold clamping mechanism 30 for injecting resin material to the mold 17.

Whereas two mold clamping mechanisms 20 and 30 are provided on the machine stand 11 in the illustrated example, three or more mold clamping mechanisms may be provided on the machine stand 11, and three or more injecting machines rather than the two injecting machines 40 and 55 may be provided in association with the three or more mold clamping mechanisms.

The first mold clamping mechanism 20 includes: a mold clamping cylinder (hereinafter referred to as "first mold clamping cylinder") 21 mounted to the underside of the upper board 13; a pressure receiving board (hereinafter referred to as "first pressure receiving board") 22 disposed under the upper board 13 and drivable by the first mold clamping cylinder 21; tie rods 23 extending upward from the first pressure receiving board 22 to pass through the upper board 13; and a movable plate (hereinafter referred to as "first movable plate") 24 secured to and connecting the respective upper ends of the tie rods 23.

As the first mold clamping cylinder 21 is extended, the first movable plate 24 moves downward or descends so that the mold 16 is clamped between the turntable 14, functioning also as a stationary plate, and the first movable plate 24.

The mold 16 comprises a movable mold (hereinafter referred to as "first movable mold") 26 mounted to the first movable plate 24, and a stationary mold (hereinafter referred to as "first stationary mold") 27 mounted to the turntable 14. A pneumatic ejection mechanism is mounted to the first movable mold 26, as will be detailed later.

The second mold clamping mechanism 30 includes: tie rods 31 extending upward from the upper board 13; a pressure receiving board (hereinafter referred to as "second pressure receiving board") 32 secured to and connecting the respective upper ends of the tie rods 31; a movable plate (hereinafter referred to as "second movable plate") 33 connected to the tie rods 31 for movement between the turntable 14 functioning also as the stationary plate and the second pressure receiving board 32; and a mold clamping cylinder (hereinafter referred to as "second mold clamping cylinder") 34 connected to the second pressure receiving board 32 for moving the second movable plate 33.

As the second mold clamping cylinder 34 is extended, the second movable plate 33 moves downward or descends so that the mold 17 is clamped between the turntable 14, functioning also as the stationary plate, and the second movable plate 33.

The mold 17 comprises a movable mold (hereinafter referred to as "second movable mold") 36 mounted to the second movable plate 33, and a stationary mold (hereinafter referred to as "second stationary mold") 37 mounted to the turntable 14.

In a lower position beneath the second mold clamping mechanism 30, an electric ejection mechanism 38 is mounted to the upper board 13. A projecting pin 39 of the electric ejection mechanism 38, which is located beneath the turntable 14 in a standby state, moves upward, in response to an ejection instruction, through the turntable 14 and the second stationary mold 37 and thereby pushes a molded part or workpiece upward from the second stationary mold 37. A pneumatic ejection mechanism is mounted to the second movable mold 33, as will be detailed later.

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The first injecting machine **40** is an electric injecting machine that includes: an injection unit moving mechanism (hereinafter referred to as "first injection unit moving mechanism") **42** mounted on a support post **41** extending upward from the upper board **13**; a slider **44** vertically movably fitted over a rail **43** fixed to and extending along the support post **41** and drivable by the first injection unit moving mechanism **42**; a heating cylinder **45** extending downward from the slider **44** and having a screw provided therein; a ball thread shaft **46** for moving the screw forward and backward; a nut **47**; and a screw moving electric motor **48**.

The first injection unit moving mechanism **42** includes a feed screw shaft **51** rotatably supported on the support post **41**, a nut **52** screwed on the feed screw **51** and operatively connected to the slider **44**, and a first injection unit moving electric motor **53** for rotating the feed screw **51**.

The second injecting machine **55** in the instant embodiment is of another type than the electric type as will be later detailed, although it may be an electric injecting machine like the first injecting machine **40**.

As shown in FIG. 2, the first movable plate **24**, which has a substantially triangular shape as viewed in plan, has three tie rods **23** disposed respectively at three apex portions of the triangle, and one of the three tie rods **23** is located at the pivot center **15** of the turntable **14**. Because the remaining two tie rods **23** are located away from the turntable **14**, pivoting movement of the turntable **14** would not be disturbed by the rods **23**.

Further, the second movable plate **33**, which has a rectangular shape as viewed in plan, has four tie rods **31** disposed respectively at four apex portions of the rectangle, and all of the four tie rods **31** are located away from the turntable **14**, so that pivoting movement of the turntable **14** would not be disturbed by the rods **31**.

Further, as shown in FIG. 3, the first stationary mold **27** is disposed under and clampable by the first movable plate **24** indicated by an imaginary line, while the second stationary mold **37** is disposed under and clampable by the second movable plate **33** indicated by an imaginary line.

In response to pivoting movement of the turntable **14**, the first stationary mold **27** angularly moves between a position under the first movable plate **24** and a position under the second movable plate **33**. Similarly, in response to pivoting movement of the turntable **14**, the second stationary mold **37** angularly moves between a position under the second movable plate **33** and a position under the first movable plate **24**.

The following detail a construction of the second injecting machine **55**. As shown in FIG. 4, the second injecting machine **55** includes a nozzle **56** screwed into the second movable mold **36**, and a material feed device **58** for feeding or supplying liquid material into the nozzle **56**.

The material feed device **58** includes: a stirring and mixing mechanism **60** for sufficiently stirring (or agitating) and mixing liquid resin material comprising base resin and an additive agent, such as a curing agent, added to the base resin; a pump mechanism **80** for pressure-feeding the stirred and mixed liquid resin material; and a measure and supply mechanism **90** for measuring a predetermined amount of the liquid resin material to intermittently supplying the liquid resin material to the second movable mold **36** via a second flow path **91**.

As shown in FIG. 5, the stirring and mixing mechanism **60** includes: a base **61**, a rotary table **64** rotatably mounted on the base **61** via a thrust bearing **62** and a radial bearing **63**; a speed-reducer-equipped motor **65** mounted on the base **61** for rotating the rotary table **64**; a cylinder **66** vertically provided laterally of the base **61**; a horizontal bar **68** fixed to a piston rod **67**, extending upward from the cylinder **66**, and extending

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horizontally; a rod **69** extending vertically downward from the distal end of the horizontal bar **68**; anchor-shaped stirring blades **71** fixed to the lower end of the rod **69**; a lid **72** fixed to a halfway position of the rod **69**; a flexible hose **73** extending from the lid **72**; and a vacuum pump **74** connected to the distal end of the flexible hose **73**. Whereas the vacuum pump **74** is shown as placed on the horizontal bar **68**, the vacuum pump **74** may be installed at any other desired position.

A container **77** containing the liquid resin material **76** comprising the base resin and the additive agent, such as a curing agent, added to the base resin is placed on the rotary table **64**. Then, with the stirring blades **71** submerged in the liquid resin material **76**, the rod **69** is lowered until an upper opening of the container **77** is closed with the lid **72**. Because the lid **72** has a seal member attached thereto the lid, the container **77** is tightly sealed with the lid **72**.

The rotary table **64** is rotated by the motor **65** at a rate of one rotation per second, in response to which the container **77** rotates relative to the blades **71** kept in a stationary state, so that the liquid resin material **76** rotates with the container **77**. At the same time, the interior pressure of the container **77** is lowered by the vacuum pump **74** to a negative pressure (lower than the atmospheric pressure).

Because of a difference in relative rotation between the container **77** and liquid resin material **76**, vertical (or up-down) circulating flows are produced in the liquid resin material **76** in addition to flows about the rod **69**. With such three-dimensional flows of the liquid resin material **76**, the additive agent is uniformly mixed into the base resin. Air bubbles contained in the liquid resin material **76** are pushed upward to the liquid level **79** by the vertical circulating flows. Because a space between the lid **72** and the liquid level **79** is under the negative pressure, the air bubbles go upward from the liquid level **79** toward the vacuum pump **74**.

The stirring and mixing mechanism **60**, which is called a "vacuum stirring and mixing device", removes the air bubbles by vacuum and promotes mixing by stirring. Upon completion of the stirring and mixing (including deaeration) of a predetermined time length, the container **77** is transferred to a next step. Then, the pump mechanism **80** is attached to the transferred container **77**.

As shown in FIG. 6, the pump mechanism **80** includes: a circular plate **82** of a small lid shape; an intake tube **83** projecting from the center of the circular plate **82**; a pump casing **84** connected to the upper end of the intake tube **83**; a pump motor fixed to the upper surface of the pump casing **84** for rotating pump impellers, built in the pump casing **84**, at a high speed; and a discharge tube **86** extending laterally from the pump casing **84**.

The content of the container **77** is the liquid resin material **76** having been sufficiently mixed. The circular plate **82** is inserted from above into the container **77** and placed on the upper surface (liquid level) of the liquid resin material **76**. The circular plate **82** has a seal member **89**, such as an O-ring, attached thereto, so that it is tightly fitted along the inner peripheral surface of the container **77**. Then, the pump motor **85** is activated, and the liquid resin material **76** is discharged through the discharge tube **86**. Although the upper surface (liquid level) of the liquid resin material **76** lowers in response to the discharge of the liquid resin material **76** through the discharge tube **86**, outside air can be reliably prevented from entering under the circular plate **82** because the circular plate **82** moves downward together with the upper surface (liquid level) of the liquid resin material **76**, and thus, air can be reliably prevented from mixing into the liquid resin material **76**.

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The liquid resin material **76** is pressure-fed by the pump mechanism **80** to the measure supply mechanism **90** via a first flow path **81**. As shown in FIG. 7, the measure supply mechanism **90** includes: a body section **95** having a pot portion **92** for storing the liquid resin material, an inlet **93** for introducing the liquid resin material **76** into the pot portion **92**, and an outlet **94** for discharging the liquid resin material from the pot portion; a plunger **96** movably mounted to the body section **95** in such a manner that it retracts (ascends in the illustrated example) due to pressure of the liquid resin material having accumulated in the pot portion **92**; a plunger pusher **97** provided in the body section **95** for pushing forward or advancing the plunger **96**; an inflow valve **98** provided in the first flow path **81** for blocking or permitting flows of the liquid resin material; and an outflow valve **99** provided in the second flow path **91** for blocking or permitting flows of the liquid resin material.

The plunger pusher **97** includes: a bracket **101** provided on an upper portion of the body section **95**; a plurality of rods **102** extending upward from the bracket **101**; a top plate **103** fixed to the upper ends of the rods **102**; a nut **104** provided under the top plate **103** for being guided by the rods **102**; a piston rod **105** formed integrally with the nut **104**; a feed screw **106** screwed through the nut **104** to extend upward; a thrust bearing **107** provided on the top plate **103** to rotatably support an upper portion of the feed screw **106**; a driven pulley **108** mounted on the upper end of the feed screw **106**; a servo motor **109** provided on the top plate **103**; a drive pulley **112** mounted on the motor shaft **111** of the servo motor **109**; a belt **113** operatively interconnecting the drive pulley **112** and the driven pulley **108**; and a control section **114** for controlling the servo motor **109**.

A pressure meter **115** for measuring pressure of the liquid resin material near the outlet **94** is mounted to the body section **95** of the measure supply mechanism **90**. Further, an accommodating case **116** is fixed to the upper end of the plunger **96**, and a proximity sensor **117** for detecting a state of contact between the piston rod **105** and the case **116** is accommodated in the case **116**.

The above-mentioned inlet **93** is offset, in the axial direction of the plunger **96**, from the outlet **94** toward the plunger pusher section **97** by a distance **L**. Further, the plunger **96** has a material flow path **121** formed therein for directing the liquid resin material, supplied via the inlet **93**, even to the distal end of the plunger **96** when the plunger **96** is in its most advanced position. Such a material flow path **121** is preferably in the form of a helical groove **122** formed in the outer peripheral surface of the plunger **96**. The helical groove **122** can eliminate a possibility of the plunger **96** being subjected to force acting in a direction substantially normal to the plunger **96** and thus can decrease frictional sliding resistance between the plunger **96** and the body section **95**. Also, the helical groove **122** can have a greater flow path resistance than a linear groove and thereby prevent unwanted flow-back of the liquid resin material.

The following describe behavior of the measure and supply mechanism **90** constructed in the aforementioned manner. The piston rod **105** stands by at a predetermined position, i.e. at a preset measure-completed position. Once the accommodating case **116** contacts the piston rod **105** in response to the plunger **96** being pushed upward by the liquid resin material, the contact between the accommodating case **116** and the piston rod **105** is detected by the proximity sensor **117**, so that it is detected that the plunger **96** has reached a predetermined position. If there is any concern that false detection may be made by the proximity sensor **117**, detection by the proximity sensor **117** and measurement of a predetermined time interval

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may be used in combination to prevent such false detection. In an alternative, the proximity sensor **117** may be replaced with a high-precision position detection means. Once the plunger **96** having reached predetermined position is detected, it is determined that the measurement of the predetermined amount of the liquid resin material has been completed.

Then, the inflow valve **98** is closed, while the outflow valve **99** is opened. The piston rod **105** is lowered by the servo motor **109** producing first torque that is predetermined torque. Then, the plunger **96** advances so that the liquid resin material is supplied to the mold via the second flow path **91**. During the supply of the liquid resin material, pressure of the liquid resin material is measured by the pressure meter **115**, and the thus-measured pressure of the liquid resin material is sent to the control section **114**.

Once the pressure of the liquid resin material reaches a predetermined pressure level, the control section **114** changes the torque of the servo motor **109** to second torque smaller than the first torque and then controls the pressure of the liquid resin material. Such control is called "follow-up pressure control". When the plunger **96** has advanced to its advance limit position or when the liquid resin material supply time has reached a predetermined time length, injection of the liquid resin material supply time into the mold cavity is completed.

Next, a description will be given about a drive system for the embodiment of the injection molding apparatus of the present invention.

As shown in FIG. 8, pneumatic ejection mechanisms **124** for pushing down a molded product are provided for the first movable mold **26**, while pneumatic ejection mechanisms **125** for pushing down a molded product are provided for the second movable mold **36**. Note that the pneumatic ejection mechanisms **124** and **125** may be in the form of pneumatic-hydraulic cylinders rather than pneumatic cylinders. The pneumatic-hydraulic cylinder is also called "air-hydro cylinder", which is a special cylinder where oil is compressed by a piston rod of an air cylinder so as to supply the compressed oil to a hydraulic cylinder. Because the oil is an incompressible fluid, the piston rod of the hydraulic cylinder does not change in position even when subjected to load variation. Further, in this case, no hydraulic pressure source is required because what has to be supplied is compressed air.

The instant embodiment of the injection molding apparatus **10** further includes, as drive sources, an electric power supply source **126**, a compressed air supply source **127** and a single hydraulic pressure supply source **128**. From the electric power supply source **126**, electric power is supplied to the first injection unit moving electric motor **53**, screw moving electric motor **48**, servo motor **109**, electric ejection mechanism **38** and turntable drive motor **129**.

The compressed air supply source **127** includes an air compressor, and a reserve tank for reserving compressed air, and compressed air is supplied from the compressed air supply source **127** to the pneumatic ejection mechanisms **124** and **125**. The hydraulic pressure supply source **128** includes an oil tank for storing return oil and a hydraulic pump for pumping and pressure-feeding oil, as will be later detailed.

A hydraulic-pressure-supply-destination selection section **130** is provided between the hydraulic pressure supply source **128** and loads (first mold clamping cylinder **21** and second mold clamping cylinder **34**). The hydraulic-pressure-supply-destination selection section **130** supplies hydraulic pressure to any one of the first mold clamping cylinder **21** and second mold clamping cylinder **34**. Namely, pressure oil is selectively sent to any one of the first mold clamping cylinder **21** and second mold clamping cylinder **34**.

As shown in FIG. 9, a hydraulic pump 131, which is a principal component of the hydraulic pressure supply source 128, includes a pump section 132, and a servo motor 133 as a drive motor for rotationally driving the pump section 132. In this case, an AC servo motor (AC motor) connected to a servo circuit is used as the servo motor 133, and a rotary encoder 134 is connected to the servo motor 133 for detecting the number of rotations of the servo motor 133. A pressure sensor 135 is also provided for detecting discharge pressure of the pump section 132.

Thus, by variably controlling the number of rotations of the servo motor 133, the instant embodiment can enhance responsiveness of the hydraulic pump 131 but also vary a discharge flow rate and discharge pressure of the hydraulic pump 131, on the basis of which it can perform drive control on the first mold clamping cylinder 21 and second mold clamping cylinder 34. In the aforementioned manner, the instant embodiment can achieve enhanced energy conservation performance and reduced running cost, but also enhanced accuracy of control and enhanced operability of the injection molding apparatus.

The following describe overall behavior of the embodiment of the injection molding apparatus 10 of the present invention. FIG. 10 is a time chart illustrating behavior of the injection molding apparatus 10, where step numbers S1 to S13 are plotted on the horizontal axis. S1 to S6 represent behavior from the start of operation of the injection molding apparatus 10 to the start of full-capacity operation of the injection molding apparatus 10, and S6 to S13 represent behavior in the full-capacity operation. Namely, the turntable 14 is turned at step S1, and mold clamping is performed by the first molding clamping mechanism 20 at step S2. Then, resin material (thermoplastic resin) is injected into the clamped mold (i.e., mold having been clamped by the first molding clamping mechanism 20) at step S3, cooling of the mold is performed, and measurement of the resin material for the next injection of the resin material is performed at step S4. Upon completion of the mold cooling, the mold is opened at step S5. At that time, ejection of the molded part or workpiece is performed by the first movable mold 26 in order to prevent the molded product from sticking to the upper mold.

Now that turning of the turntable 14 has been made possible, the turntable 14 is turned through 180 degrees at step S6. Then, mold clamping is performed by the second molding clamping mechanism 30 at step S7. Then, resin material (liquid resin) is injected into the clamped mold (i.e., mold having been clamped by the second molding clamping mechanism 30) at step S8-2, cooling of the mold is performed, and then measurement of the resin material (liquid resin) for the next injection is performed at step S9-2. Upon completion of the mold cooling, the mold is opened at step S12. At that time, ejection of the molded product is performed by the second movable mold 36 in order to prevent the molded product from sticking to the upper mold. Then, the molded product is ejected from the mold at step S13.

In parallel with the above, mold clamping is performed by the first mold clamping mechanism 20 at step S8-1, the resin material (thermoplastic resin) is injected into the clamped mold at step S9-1, cooling of the mold is performed, and then measurement of the resin material for the next injection is performed at step S10-1. Upon completion of the mold cooling, the mold is opened at step S11-1. At that time, ejection of the molded product is performed by the first movable mold 26 in order to prevent the molded product from sticking to the upper mold.

As clear from the figure, the mold clamping by the first mold clamping mechanism 20 at step S8-1 is started in

response to a mold clamping completion signal generated at step S7, and the mold opening by the second mold clamping mechanism 30 at step S12 is started in response to a first mold opening completion signal generated at step S11-1. Such operations are carried out under control of the hydraulic-pressure-supply-destination selection section 130 (FIG. 8). Namely, control is performed by the hydraulic-pressure-supply-destination selection section 130 such that the operations of steps S7 and S8-1 do not overlap each other and the operations of steps S11-1 and S12 do not overlap each other.

The foregoing description may be summarized as follows. As shown in FIG. 8, the injection molding apparatus 10 includes: the plurality of mold clamping mechanisms 20 and 30; the single hydraulic pressure supply source 128 provided for supplying mold clamping hydraulic pressure to the plurality of mold clamping mechanisms 20 and 30; the hydraulic-pressure-supply-destination selection section 130 that makes a supply destination selection such that hydraulic pressure is supplied from the hydraulic pressure supply source 128 to one of the plurality of mold clamping mechanisms 20 or 30; the turntable 140 that shifts the molds 16 and 17 from one of the mold clamping mechanisms 20 and 30 to the other of the mold clamping mechanisms 30 or 20; the injecting machines 40 and 55 provided in association with respective ones of the plurality of mold clamping mechanisms 20 and 30 for injecting resin material to the molds 16 and 17 clamped by the mold clamping mechanisms 20 and 30; and the electric power supply source 126 or the compressed air supply source 127 provided for supplying electric power or compressed air to the injecting machines 40 and 55.

Namely, in the injection molding apparatus 10 including the plurality of mold clamping mechanisms 20 and 30 and the plurality of injecting machines 40 and 55, the mold clamping mechanisms 20 and 30 are driven by hydraulic pressure while the injecting machines 40 and 55 are driven by electric power or compressed air. In the case where only the mold clamping mechanisms 20 and 30 are driven by hydraulic pressure like this, the necessary capacity of the hydraulic pump can be lowered as compared to a case where all of the mold clamping mechanisms 20 and 30 and the injecting machines 40 and 55 are driven by hydraulic pressure.

Further, in the injection molding apparatus 10, the hydraulic-pressure-supply-destination selection section 130 allows hydraulic pressure to be supplied to a selected one of the mold clamping mechanisms 20 and 30. In the case where only a selected one of the mold clamping mechanisms 20 and 30 is driven at a time like this, the necessary capacity of the hydraulic pump 131 can be halved as compared to a case where the plurality of mold clamping mechanisms 20 and 30 are driven simultaneously. Thus, the instant embodiment can significantly lower or reduce the necessary capacity of the hydraulic pump 131 and thus can reduce the size of, or downsize, the hydraulic pump 131 but also significantly reduce electricity cost required for driving the hydraulic pump 131.

Further, as shown in FIG. 8, the injection molding apparatus 10 includes the ejection mechanisms 38, 124 and 125 for ejecting a molded product from the mold, and electric power or compressed air is supplied from the electric power supply source 126 or the compressed air supply source 127 to these ejection mechanisms 38, 124 and 125. Because driving by hydraulic pressure is not employed for the ejection mechanisms 38, 124 and 125, it is not necessary to increase the capacity of the hydraulic pump, so that further size reduction of the hydraulic pump 131 can be achieved.

Furthermore, in the instant embodiment, the resin material to be injected by the injecting machine 40 is thermoplastic resin, while the resin material to be injected by the other

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injecting machine 55 is non-thermoplastic resin different from the thermoplastic resin. By provision of the hydraulic-pressure-supply-destination selection section 130, mold clamping by the one mold clamping mechanism 20 and mold clamping by the other mold clamping mechanism 30 can be performed with a proper time difference therebetween or at proper non-overlapping timing, and mold opening by the one mold clamping mechanism 20 and mold opening by the other mold clamping mechanism 30 can be performed with a proper time difference therebetween or at proper non-overlapping timing. Thus, even different kinds of material that differ from each other in length of time necessary for being cooled within the respective molds can be used for injection molding by the injection molding apparatus 10, and thus, double-color molding etc. can be performed with ease by the injection molding apparatus 10.

The basic principles of the present invention are well suited for application to double-color molding apparatus.

Obviously, various minor changes and modifications of the present invention are possible in light of the above teaching. It is therefore to be understood that within the scope of the appended claims the invention may be practiced otherwise than as specifically described.

What is claimed is:

1. An injection molding apparatus comprising:
 - a plurality of injection molds;
 - a plurality of mold clamping mechanisms for clamping the respective plurality of injection molds;
 - a turntable mounted to undergo turning movement for shifting the injection molds between the mold clamping mechanisms;
 - a single hydraulic pressure supply source for supplying mold clamping hydraulic pressure to the plurality of mold clamping mechanisms;
 - a hydraulic-pressure-supply-destination selection section for making a hydraulic-pressure supply destination selection such that hydraulic pressure is selectively supplied from the single hydraulic pressure supply source to any one of the plurality of mold clamping mechanisms;
 - a plurality of injecting machines provided in association with the plurality of mold clamping mechanisms for injecting resin material to the injection molds clamped by corresponding ones of the mold clamping mechanisms; and
 - an electric power supply source or a compressed air supply source provided for supplying driving electric power or compressed air to the plurality of injecting machines; wherein one of the injecting machines is configured for injecting a thermoplastic resin, and another of the injecting machines is configured for injecting a non-thermoplastic resin.
2. The injection molding apparatus according to claim 1, further comprising an ejection mechanism for ejecting a molded product from each of the injection molds, and wherein the driving electric power or compressed air is supplied from the electric power supply source or the compressed air supply source to the ejection mechanism.
3. The injection molding apparatus according to claim 1, wherein the single hydraulic pressure supply source is a hydraulic pump; and further comprising a drive motor that drives the hydraulic pump under a condition that a number of rotations of the drive motor is variably controlled to thereby vary a discharge flow rate of the hydraulic pump.
4. The injection molding apparatus according to claim 1; wherein the non-thermoplastic resin is liquid mixed material obtained by stirring and mixing liquid resin material and a curing agent.

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5. The injection molding apparatus according to claim 1, wherein the plurality of mold clamping mechanisms comprises a first mold clamping mechanism including a first mold clamping cylinder, a first pressure receiving board drivable by the first mold clamping cylinder, first tie rods extending upward from the first pressure receiving board, and a first movable plate secured to and connecting the respective upper ends of the first tie rods; and a second mold clamping mechanism including second tie rods, a second pressure receiving board connecting respective upper ends of the second tie rods, a second movable plate connected to the second tie rods for movement between the turntable and the second pressure receiving board, and a second mold clamping cylinder connected to the second pressure receiving board for moving the second movable plate.

6. The injection molding apparatus according to claim 5, wherein the plurality of injection molds comprises first and second injection molds; wherein the first injection mold comprises a first movable mold mounted to the first movable plate of the first mold clamping mechanism and a first stationary mold mounted to the turntable; and wherein the second injection mold comprises a second movable mold mounted to the second movable plate of the second mold clamping mechanism and a second stationary mold mounted to the turntable.

7. The injection molding apparatus according to claim 6, wherein the turntable, the mold clamping mechanisms and the injection molds are configured so that in response to turning movement of the turntable, the first stationary mold angularly moves between a position under the first movable plate and a position under the second movable plate, and the second stationary mold angularly moves between a position under the second movable plate and a position under the first movable plate.

8. The injection molding apparatus according to claim 5, wherein the hydraulic-pressure-supply-destination selection section is provided between the hydraulic pressure supply source and the first and second mold clamping cylinders and is configured to make a hydraulic-pressure supply destination selection such that hydraulic pressure is selectively supplied from the single hydraulic pressure supply source to any one of the first and second mold clamping cylinders.

9. The injection molding apparatus according to claim 1, wherein the plurality of mold clamping mechanisms comprises a first mold clamping mechanism and a second mold clamping mechanism; and wherein the hydraulic-pressure-supply-destination selection section is configured to make the hydraulic-pressure supply destination selection so that mold clamping by the first mold clamping mechanism and mold clamping by the second mold clamping mechanism are performed with a time difference therebetween.

10. The injection molding apparatus according to claim 1, wherein the plurality of mold clamping mechanisms comprises a first mold clamping mechanism and a second mold clamping mechanism; and wherein the hydraulic-pressure-supply-destination selection section is configured to make the hydraulic-pressure supply destination selection so that mold opening by the first mold clamping mechanism and mold opening by the second mold clamping mechanism are performed with a time difference therebetween.

11. An injection molding apparatus comprising:

- at least two mold clamping mechanisms for clamping respective molds;
- a hydraulic pressure supply source for supplying hydraulic pressure to the at least two mold clamping mechanisms to clamp the respective molds;
- a hydraulic-pressure-supply-destination selection section configured to allow hydraulic pressure from the hydraulic

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lic pressure supply source to be selectively supplied to any one of the two mold clamping mechanisms;
 at least two injecting machines for injecting resin material to the respective molds clamped by the respective two mold clamping mechanisms, one of the at least two injecting machines being configured for injecting a thermoplastic resin, and the other of the at least two injecting machines being configured for injecting a non-thermoplastic resin; and
 a non-hydraulic power supply source for driving the at least two injecting machines to inject the resin material.

12. The injection molding apparatus according to claim 11, wherein the non-hydraulic power supply source comprises an electric power supply source for supplying driving electric power to the at least two injecting machines.

13. The injection molding apparatus according to claim 11, wherein the non-hydraulic power supply source comprises a compressed air supply source for supplying compressed air to the at least two injecting machines.

14. The injection molding apparatus according to claim 11, further comprising a turntable mounted to undergo pivotal movement for shifting the molds between the respective mold clamping mechanisms.

15. The injection molding apparatus according to claim 11, wherein the hydraulic-pressure-supply-destination selection section is configured to allow hydraulic pressure from the hydraulic pressure supply source to be selectively supplied to any one of the two mold clamping mechanisms so that mold clamping by one of the at least two mold clamping mechanism and mold clamping by the other of the two mold clamping mechanisms are performed with a time difference therebetween.

16. The injection molding apparatus according to claim 11, further comprising an ejection mechanism for ejecting a molded product from each of the molds, the ejecting mechanism being driven by the non-hydraulic power supply source.

17. The injection molding apparatus according to claim 11, wherein the hydraulic pressure supply source comprises a hydraulic pump; and further comprising a drive motor that drives the hydraulic pump under a condition that a number of rotations of the drive motor is variably controlled to thereby vary a discharge flow rate of the hydraulic pump.

18. The injection molding apparatus according to claim 11, wherein one of the at least two mold clamping mechanisms comprises a first mold clamping mechanism including a first mold clamping cylinder, a first pressure receiving board drivable by the first mold clamping cylinder, first tie rods extending upward from the first pressure receiving board, and a first movable plate secured to and connecting the respective upper

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ends of the first tie rods; and wherein the other of the at least two mold clamping mechanisms comprises a second mold clamping mechanism including second tie rods, a second pressure receiving board connecting respective upper ends of the second tie rods, a second movable plate connected to the second tie rods for movement between the turntable and the second pressure receiving board, and a second mold clamping cylinder connected to the second pressure receiving board for moving the second movable plate.

19. The injection molding apparatus according to claim 18, further comprising a turntable mounted to undergo pivotal movement for shifting the molds between the respective mold clamping mechanisms; and wherein the molds comprise a first mold including a first movable mold mounted to the first movable plate and a first stationary mold mounted to the turntable, and a second mold including a second movable mold mounted to the second movable plate and a second stationary mold mounted to the turntable.

20. An injection molding apparatus comprising:

a first mold clamping mechanism for clamping a first mold;
 a second mold clamping mechanism for clamping a second mold;

a single hydraulic pressure supply source for selectively supplying hydraulic pressure to the first mold clamping mechanism for performing a clamping operation to clamp the first mold and to the second mold clamping mechanism for performing a clamping operation to clamp the second mold;

a hydraulic-pressure-supply-destination selection section for making a hydraulic-pressure supply destination selection that controls the single hydraulic pressure supply source to selectively supply hydraulic pressure to the first and second mold clamping mechanisms with a time difference therebetween so that the clamping operations for clamping the first and second molds do not overlap each other;

a first injecting machine for injecting a thermoplastic resin to the first mold clamped by the first mold clamping mechanism;

a second injecting machine for injecting a non-thermoplastic resin to the second mold clamped by the second mold clamping mechanism; and

a non-hydraulic power supply source for driving the first injecting machine to inject the thermoplastic resin to the first mold clamped by the first mold clamping mechanism and for driving the second injecting machine to inject the non-thermoplastic resin to the second mold clamped by the second mold clamping mechanism.

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